

Work Order ID 53051

October 22, 2009 11:28:28 AM



Page 1

Item ID: D3884-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle, Inboard RH

Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: 11

Date: 09-10-22

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3884

B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. B53051

Double check by: LA

1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets

1/2K 09/10/31

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1/2K 09/10/31

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Page 2

Item ID: D3884-2

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Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	28 09/11/01			(4)			
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	BL 09-11-2			(4)			
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 11/12/148 Memo START TIME: 11:40 OVEN TEMPERATURE: 320° FINISH TIME: 12:10	0.00 0.00	BL 09-11-2			(4)			

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October 22, 2009 11:28:28 AM

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Revision ID: B

Stop



Item Name: Saddle, Inboard RH

Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	MD 09/11/02			X4			
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>429</u> Memo	0.00 0.00				9/11/3	(4x)	sf	
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				09/11/03		MF 09-11-03	

Picklist Print

October 22, 2009 11:28:39 AM

Page 1

Work Order ID: 53051



Parent Item: D3884-2RevB



Parent Item Name: Saddle, Inboard RH

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-017RevB		Manufactured	No			100	Each	20.0000	4.0000			

Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

20

51835

20

mm
29/10/30

4

2.866

DART AEROSPACE LTD		Work Order: 53051	
Description: Saddle, Inboard, RH		Part Number: D3884-2	
Inspection Dwg: D3884 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

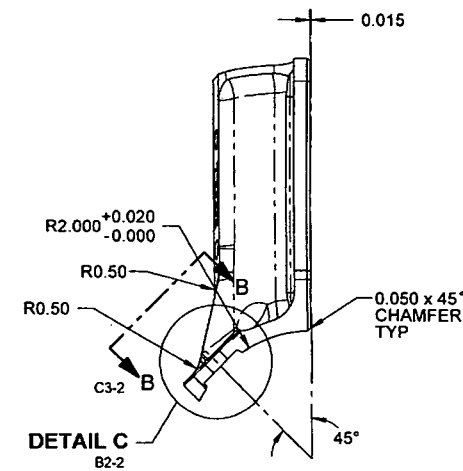
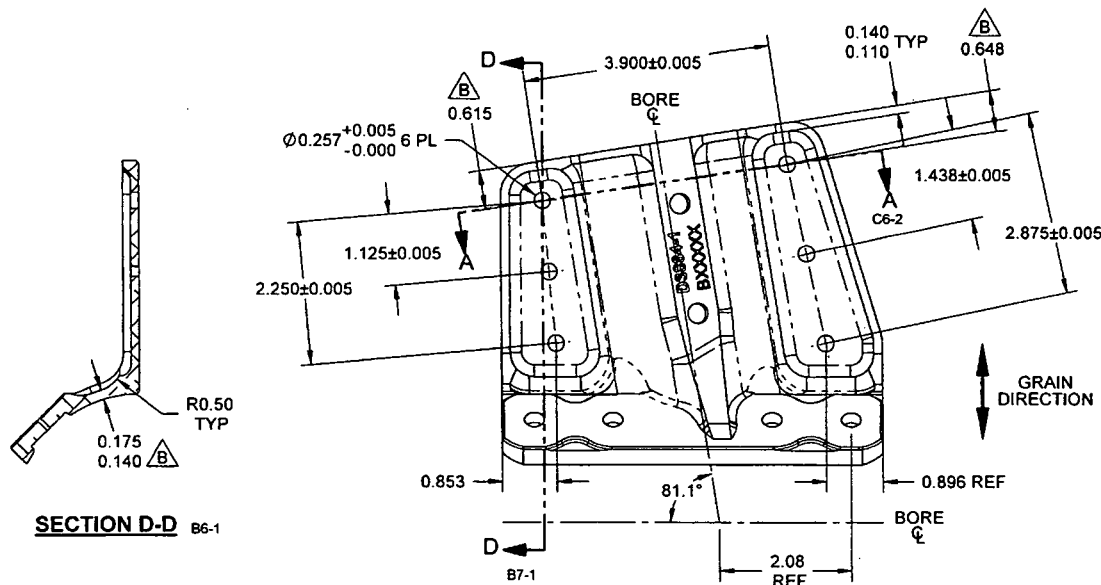
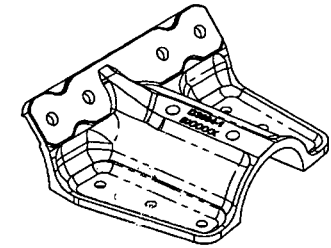
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.645	.645	.646	.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.614	.614	.614	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.005	2.004	2.006	2.005		
J	0.140	0.175		.151	.152	.152	.150		
K	1.265	1.285		1.269	1.268	1.269	1.268		
L	0.115	0.135		.124	.124	.124	.124		
M	0.240	0.260		.249	.249	.250	.249		
N	0.110	0.140		.140	.140	.140	.140		
O	0.240	0.260		.253	.253	.252	.253		
P	2.826	2.886		2.868	2.868	2.868	2.868		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.152	.153	.152	.152		
S	0.720	0.780		.760	.760	.760	.760		
T	1.220	1.280		1.260	1.260	1.260	1.260		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		5.999	5.999	5.999	5.999		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.498	.499	.499	.500		
Y	0.020	0.040		.035	.035	.035	.035		
Z	0.313	0.318		.315	.315	.315	.315		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.218	.218	.218	.218		
AC	0.316	0.321		.320	.320	.320	.320		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.003	1.004	1.002	1.002		
AF									
Accept/Reject									

Measured by:	AL
Date:	09/10/31

Audited by:	RP
Date:	09/10/01

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO A
WITHOUT
WORK
NO. 53051
PR09-10-22



RELEASED
01/07/15/14

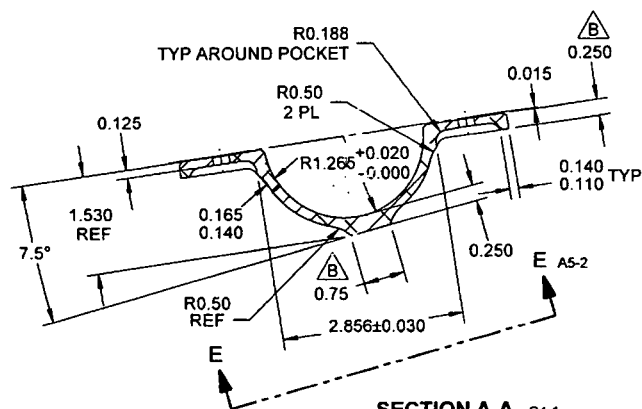
D3884-1 SADDLE, INBOARD LH (SHOWN)
D3884-2 SADDLE, INBOARD RH (OPPOSITE)

NOTES:

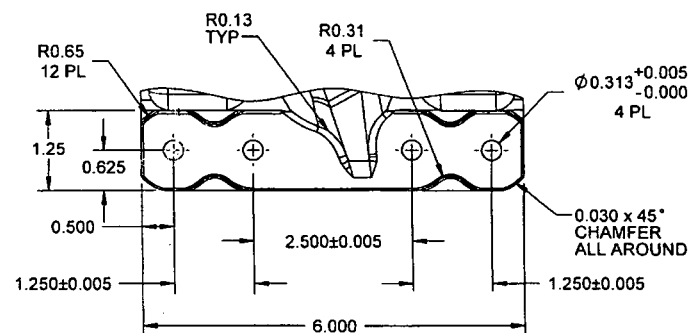
- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-2; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165. ZN B7-1; ADD 0.615. ZN C6-1; ADD 0.648. ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.060. ZN C2-2; 0.75 WAS 0.65. ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.		D3884	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INBOARD SADDLE	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

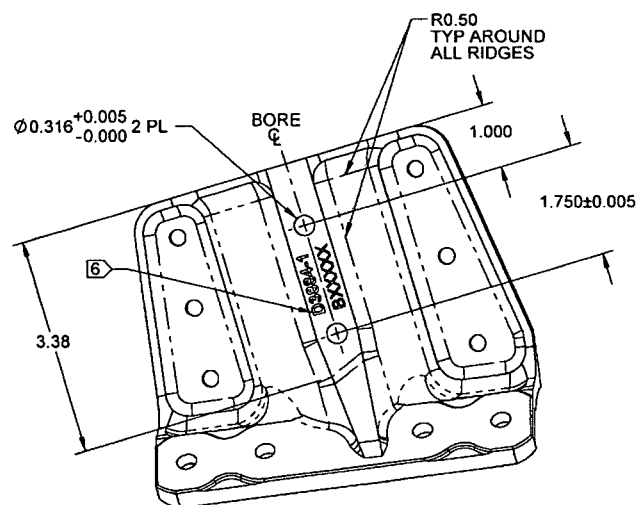
8	7	6	5	4	3	2	1
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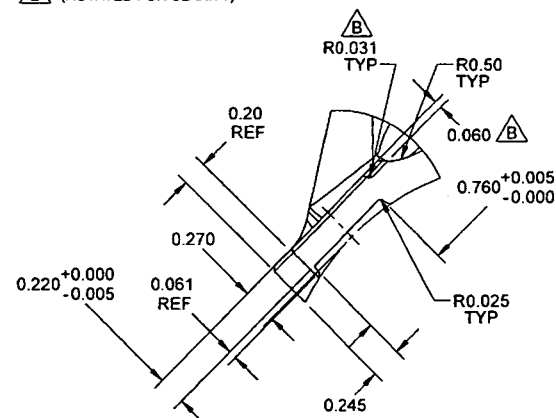
SECTION A-A C4-1



 **VIEW B-B** B3-1
(ROTATED FOR CLARITY)



VIEW E-E C6-2



DETAIL C B3-1
SCALE 2X

RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D3884	SHEET 2 OF 2
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	INBOARD SADDLE	NTS
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